

In the Claims:

1. In an expendable and machinable material capable of being cast in blocks machined to a desired shape, said material containing ethylene-vinyl resin and fatty acid ketone, the improvement consisting of the addition of at least one fatty acid.

2. An expendable and machinable pattern material capable of being cast in large blocks and machined to a casting shape useful in the lost pattern process of investment casting, said material consisting of essentially of ethylene-vinyl resin, at least one fatty acid ketone and at least one fatty acid.

3. A pattern material as claimed in claim 2 containing in amounts by weight:

5-20 % ethylene-vinyl resin,

25-75 % fatty acid,

25-75 % fatty acid ketone,

0-20 % of at least one ingredient compatible with said ethylene-vinyl resin, fatty acid and fatty acid ketone.

4. A pattern material as claimed in claim 2 containing an amounts by weight:

8-15 % ethylene-vinyl resin,

38-62 % at least one fatty acid,

38-62 % at least one fatty acid ketone.